

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010765**Date Inspected:** 13-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector witnessed final tension verification for I stiffener splice at transition location (North and South) of 1AE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP8.5 to PP9: M22 X 100 – DHGM 220049 – 493 NM

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed U-Rib dimensional survey along with QA inspector (Mr. Manjunath) for below segment. Reports forwarded to team leader for further action

6BE-6CE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6BE-6CE)

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SMAW Process:

Welding of weld joint –023 located on PCMK DP636-001, Deck panel I-Rib CJP Bike path side (E2). Welder is identified as 054467. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

SMAW Process:

Welding of weld joint –025 located on PCMK DP636-001, Deck panel I-Rib CJP Bike path side (E2). Welder is identified as 048659. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

OBG # TRIAL ASSEMBLY YARD (6BE-6CE)

SMAW Process:

Welding of weld joint –007 located on PCMK DP517-001, Deck panel I-Rib CJP weld crossbeam side (E5). Welder is identified as 048659. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

OBG # TRIAL ASSEMBLY YARD (6BE)

FCAW Process:

Welding of weld joint –032 located on PCMK SEG030B, Longitudinal web to floor beam at E5 side. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

OBG # TRIAL ASSEMBLY YARD (6CE)

SMAW Process:

Welding of weld joint at X37K located on PCMK CA030, Corner assembly stiffener between PP45 and PP45.5. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. Welding was been performed against Welding repair report: B-WR8987 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345+485-SMAW-3G (3F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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